

Work Order ID 148360

Friday, July 08, 2016 8:15:47 AM

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Item ID: D3705-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Instrument Panel Weldment
 Start Date: 7/12/2016 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 7/20/2016 Req'd Qty: 3.00 *3* Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3705	E								

100 Weld per dwg A/R Aluminum rod Batch: 14109398 0.00

100

Large Fab

Large Fab

Memo

1.99

1-Assemble and weld as per dwg D3705 per QSI004

**** weld all around and buff weld smooth as indicate on dwg****

3 11/18/15

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.01

③ 16-08-16 DAS 9 9-89

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.01

③ 16-08-16 DAS 9 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	23 24 25
130	Chemical Conversion Coat per QSI005 4.1	0.00								
130										
HandFinish	Memo	0.02				(3)			7/16/08/17	BEB
Hand Finishing										
140	QC7-Inspect Chemical Conversion Coat	0.00								
140										
QC	Memo	0.01								
Quality Control										
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00								
150										
Powdercoat	Memo	0.02								
Powder Coating	MASK INDICATED AREA PRIOR TO PAINT									
	START TIME: 9:15am									
	OVEN TEMPERATURE: 320° F									
	FINISH TIME: 9:45am									

3 0 16-08-17 23 24 25
 3 0 11/12/08/12

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				(3)			DAS 38 9-89 AUG 23 2016
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>51382</u> Memo	0.00 0.01				(2)	PC		DAS 6 9-89 AUG 24 2016 To small fish.
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.05							DAS 21 9-89 AUG 25 2016 16-8-24

Picklist Print

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Work Order ID: 148360

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Parent Item: D3705-043

D3705-043

Parent Item Name: Instrument Panel Weldment

Start Date: 7/12/2016

Required Date: 7/20/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP Rev:B 09-01-09 rev.C as per dwg DD verified by:ec IPP Rev:C as
per dwg RevD DD 10.04.27 verified by:EC IPP REV:D 12.12.03
REV PE1 DD VERF:JLM IPP REV:E 13.01.15 AS PER
DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3705-1

Manufactured

No

100

Each

7.0000

1

3

D3705-1

Main Panel

16-8-15

Location

Loc Qty

Loc Code

WA004

7

143649

7

3

D3705-3

Manufactured

No

100

Each

3.0000

1

3

D3705-3

Cover Plate

16-8-15

Location

Loc Qty

Loc Code

WA001

3

108406

3

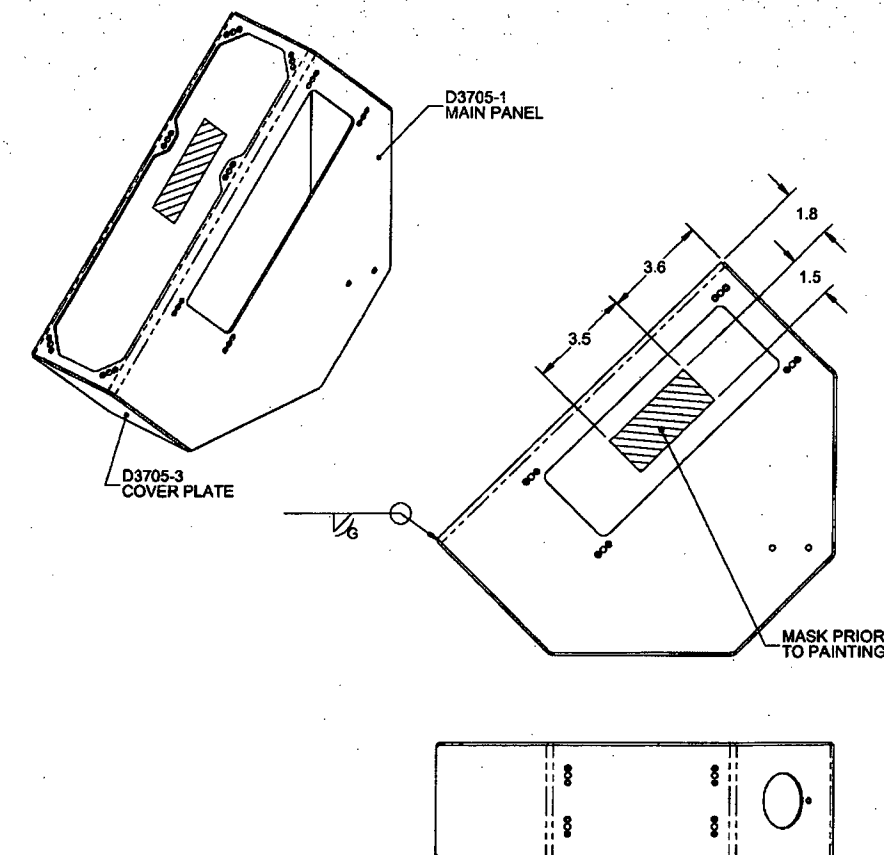
3

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED C
SUBJECT TO AMENDME
WITHOUT NOTICE
WORK ORDER
NO. 148360 MJS
1607-05

RELEASED
2013-01-14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASSY	NTS
DATE	12.11.30	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3705-043 INSTRUMENT PANEL WELDMENT

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004